

Work Order ID 135048

July 27, 2015 1:19:32 PM

135048

Page 1

Item ID: D5222-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 7/27/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/10/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: SW **20150727** Run Start ***NR1***
Date: Tooling: Date: Stop ***NR2***
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5222	A								

110 Large Fab 0.00
110
Large Fab Memo 0.00
Large Fab 1-Weld D4379-5 cups as per dwg D3859
A/R 316L stainless steel rod Batch: M123823
2-Weld hard facing as per Dwg D3859
A/R 2059B Hard Coat rod Batch: M129694
*****use DT10124 for welding*****
HARDFACING THICKNESS 0.130" MIN 0.190" MAX

86 15-08-05 MAL

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00
120
QC Memo 0.00
Quality Control

6 15-08-11 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Item ID: D5222-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 7/27/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/10/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							⑥ 1508 11 PD
Quality Control									
140	Identify as per dwg & Stock Location: <u>ST 618</u>	0.00							
140									
Packaging	Memo	0.00							6 DAS 27 9:39
Packaging									AUG 12 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							MLJ AUG 12 2015
Quality Control									

MLJ AUG 12 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 135048

135048

Parent Item: D5222-041

D5222-041

Parent Item Name: Wearplate Assembly

Start Date: 7/27/2015

Required Date: 8/10/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.02.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-5		Manufactured	No				Each	33.0000		16			

D4379-5

Wearplate Cup

**

Location

Loc Qty

Loc Code

ST103

4

126889

4

WA001

29

129613

10

133126

19

x12

Each

0.0000

x12

15-08-05 MAL

D5222-1

Manufactured

No

D5222-1

Wearplate

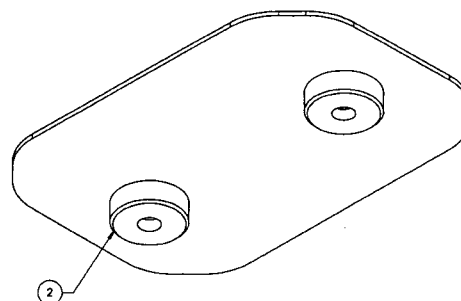
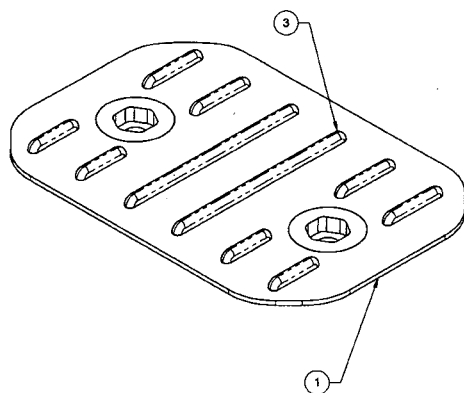
**

B135049 x6

x6

15-08-05 MAL

ITEM	QTY	P/N	DESCRIPTION
X	X	D5222-041	WEARPLATE ASSEMBLY
1	1	D5222-1	R22 WEARPLATE
2	2	D4379-5	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D5222-041 WEARPLATE ASSEMBLY

RELEASED

2015 FEB 23
E.C.N. 15-524 4P

A	NEW ISSUE	VS	15.02.04
REV	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	15.02.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO

D5222

TITLE

WEARPLATE

REV. A

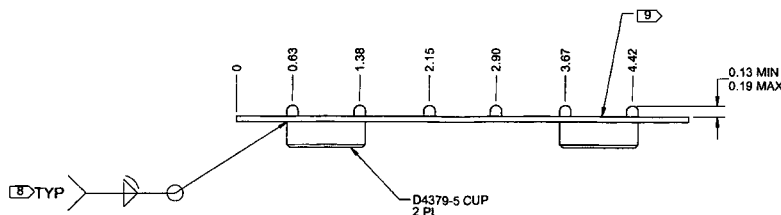
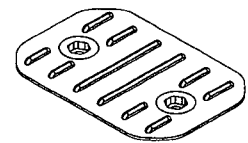
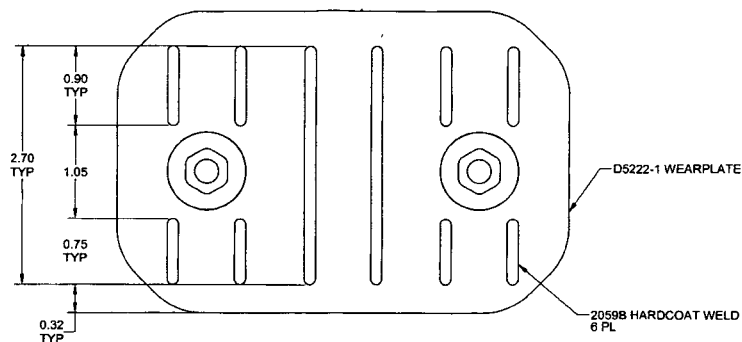
SHEET 1 OF 3

SCALE

NTS

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SW 20150727
135048

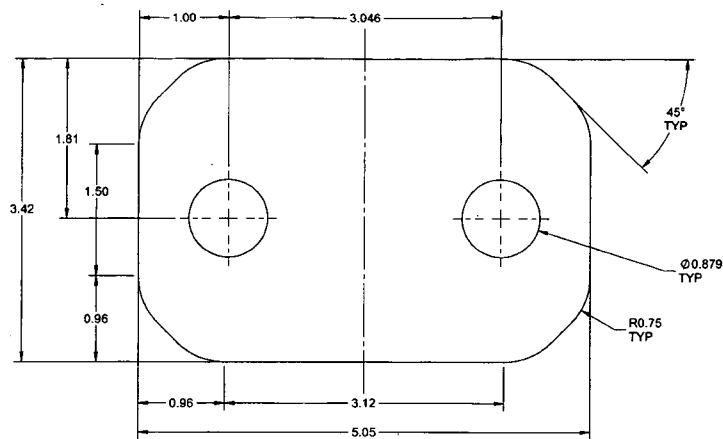


RELEASED
2015 FEB 23rd

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: 0.42 lbs
8) WELDING PER QSI 004
9) D4379-5 FLUSH WITH SURFACE

D5222-041 WEARPLATE
WELDING DETAIL

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5222	SHEET 2 OF 3
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DE APPR.	DS	WEARPLATE	NTS
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D5222-1 R22 WEARPLATE

RELEASED
2015 FEB 23

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. A
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